

[Dart Hawkesbury] Job Sheet - David, Logan



Tel (613) 632-5200

5655

Part No: RBEM622V4008101 Job Qty: 1 ea

Part Name: Main Rotor Head Damper Setting Tool

**Part Weight: 0 lbs**

Status: At Planning

Priority: Medium

Job Created: 5/28/18

Job Tracking No:

Due Date: 7/16/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBEM622V4008101 Rev. 3 IPP Rev. A 18.05.17 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		7/16/18	0.00	0.00	Start Up Small Fab-4		MCC
100	Small Fab	1 pcs		7/16/18	0.00	0.50	Small Fab-9		MCC
110	QC	1 pcs		7/16/18	0.00	0.00	QC5		S.B
130	Packaging	1 pcs		7/16/18	0.00	0.00	Packaging3-2		MCC
140	QC21-FG	1 Ea		7/16/18	0.00	0.00	QC21	DAS	

Part Op **100** - Assemble as per DWG.
 Descriptions: **130** - Identify and Stock

DAG
21
3-85

~~SEP 26 2018~~

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBEM622V4008101-1	Base	1 Ea (1 ea)	90-Start up Operation	5093512
92290A330	Socket Cap Screw	9 Ea (9 ea)	100-Small Fab	507700
98381A510	Pin	2 Ea (2 ea)	100-Small Fab	5075952
RBEM622V4008101-11	Fastener	1 Ea (1 ea)	100-Small Fab	51081628
RBEM622V4008101-13	Fastener 2	1 Ea (1 ea)	100-Small Fab	5108611
RBEM622V4008101-15	Cap	4 Ea (4 ea)	100-Small Fab	5109109
RBEM622V4008101-17	Foam Block	2 Ea (2 ea)	100-Small Fab	5092100
RBEM622V4008101-3	Measurement Block	1 Ea (1 ea)	100-Small Fab	5092415
RBEM622V4008101-5	Support 1	1 Ea (1 ea)	100-Small Fab	5109664
RBEM622V4008101-7	Support 2	1 Ea (1 ea)	100-Small Fab	5109910
RBEM622V4008101-9	Support 3	1 Ea (1 ea)	100-Small Fab	5109772

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	RBEM622V4008101-1	1	0	0
100-Small Fab	92290A330	9	0	0
	98381A510	2	0	0
	RBEM622V4008101-11	1	0	0
	RBEM622V4008101-13	1	0	0
	RBEM622V4008101-15	4	0	0
	RBEM622V4008101-17	2	0	0
	RBEM622V4008101-3	1	0	0
	RBEM622V4008101-5	1	0	0
	RBEM622V4008101-7	1	0	0
	RBEM622V4008101-9	1	0	0

Part Specifications

Specifications could not be found.

Plex 5/28/18 2:40 PM dart.logan.david



Container No: S113622



Part: RBEM622V4008101

Job No: 178180

Serial No/Batch: S113622

Revision: 3

Inspector:

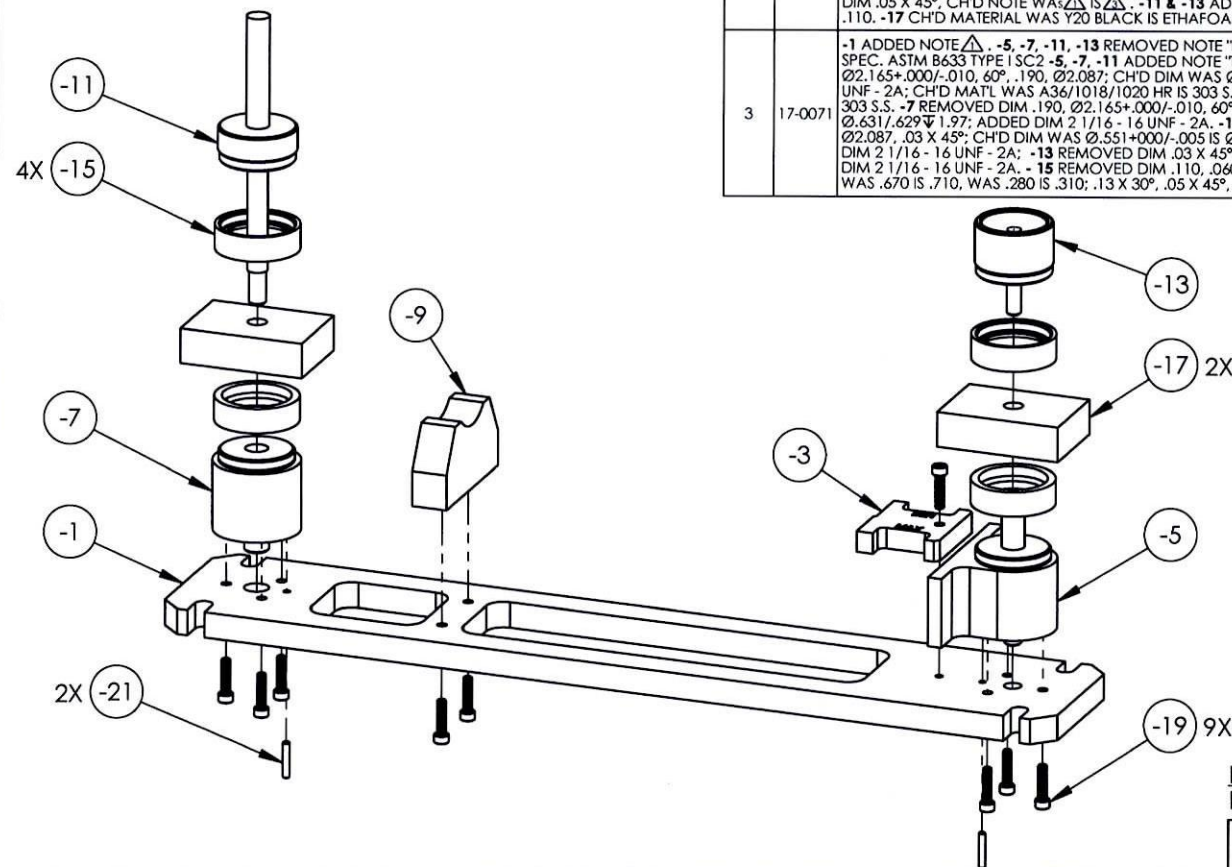
Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 09/26/18

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION	6/14/2016	SM	JAG
2	16-0173	-1 CH'D DIM WAS 8X Ø.260 $\pm$ 2.63 IS 8X Ø.260 THRU ALL, CH'D DIM WAS 3X 2.368 IS 7X 2.368, ADDED INK STAMP T/N, S/N, "MADE IN USA". -3 CH'D MATERIAL WAS A36/1018/1020 HR IS 303 S.S., MOVED ENGRAVE P/N NOTE LOCATION, DELETED NOTES 1, 2 AND 3. -5 CH'D DIM WAS Ø2.165 IS Ø2.165 $\pm$.000/-0.010, ADDED BREAK EDGE NOTE. -7, -11, & -13 CH'D MAT'L WAS A36/1018/1020 HR IS STRESSPROOF, CH'D DIM WAS Ø2.165 IS Ø2.165 $\pm$.000/-0.010, ADDED BREAK EDGE NOTE. -7 ADDED DIM .05 X 45°, CH'D NOTE WAS Δ IS Δ . -11 & -13 ADDED ENGRAVE P/N. -15 CH'D DIM WAS .090 IS .110. -17 CH'D MATERIAL WAS Y20 BLACK IS ETHAFOAM 220, BLACK, (CASE SOLUTIONS).	10/17/2016	RJC	SM
3	17-0071	-1 ADDED NOTE Δ . -5, -7, -11, -13 REMOVED NOTE "BREAK EDGE", REMOVED FINISH ZINC PLATE SPEC. ASTM B633 TYPE 1 SC2 -5, -7, -11 ADDED NOTE "THREAD RELIEF". -5 CH'D REMOVED DIM Ø2.165 $\pm$.000/-0.010, 60°, .190, Ø2.087; CH'D DIM WAS Ø.630 IS Ø.627/.625; ADDED DIM 2 1/16 - 16 UNF - 2A; CH'D MAT'L WAS A36/1018/1020 HR IS 303 S.S. -7, -11, -13 CH'D MAT'L WAS STRESSPROOF IS 303 S.S. -7 REMOVED DIM: .190, Ø2.165 $\pm$.000/-0.010, 60°, Ø2.087; CH'D DIM WAS Ø.625 $\pm$ 1.97 IS Ø.631/.629 $\pm$ 1.97; ADDED DIM 2 1/16 - 16 UNF - 2A, -11 REMOVED DIM Ø2.165 $\pm$.000/-0.010, 60°, .190, Ø2.087, .03 X 45°; CH'D DIM WAS Ø.551 $\pm$.003 IS Ø.551 $\pm$.003, WAS Ø.638 IS Ø.627/.625; ADDED DIM 2 1/16 - 16 UNF - 2A, -13 REMOVED DIM .03 X 45°, .190, 60°, Ø2.087, Ø2.165 $\pm$.000/-0.010; ADDED DIM 2 1/16 - 16 UNF - 2A, -15 REMOVED DIM .110, .060, .070, .140, .080, 12X .063, 11X 30°; CH'D DIM WAS .670 IS .710, WAS .280 IS .310, .13 X 30°, .05 X 45°, Ø1.74, 2 1/16 - 16 UNF - 2B.	3/23/2017	SM	JAG

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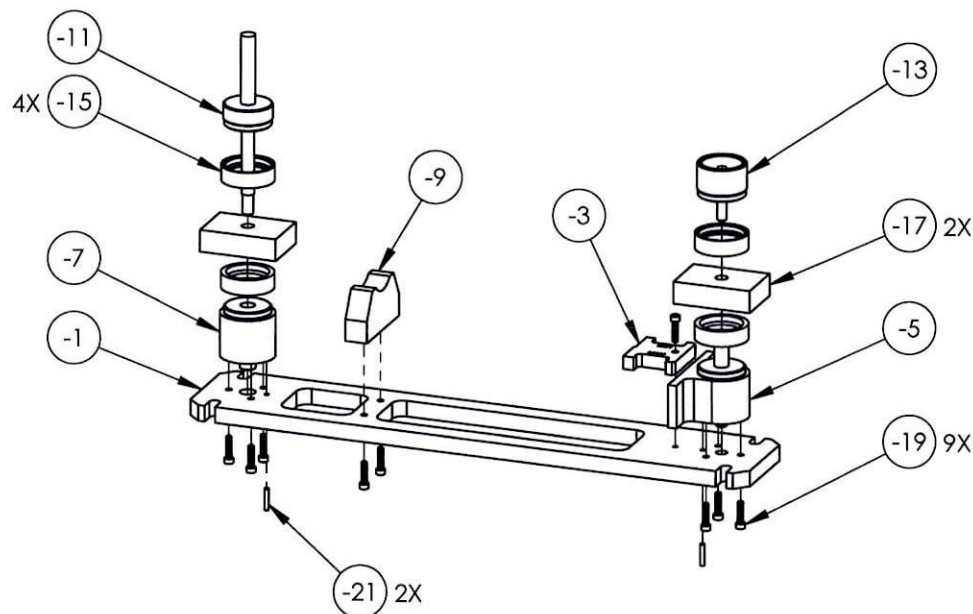
NOTE:
REF. AIRBUS T/N: M622V4008101.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	BASE	A36/1018/1020 HR		2
			-3	1	MEASUREMENT BLOCK	303 S.S.		3
			-5	1	SUPPORT 1	303 S.S.		4
			-7	1	SUPPORT 2	303 S.S.		5
			-9	1	SUPPORT 3	6061		6
			-11	1	FASTENER 1	303 S.S.		7
			-13	1	FASTENER 2	303 S.S.		8
			-15	4	CAP	BLACK DELRIN/ACETAL		9
		B/O	-17	2	FOAM BLOCK	ETHAFOAM 220, BLACK	3.50 X 2.45 X 1.00 (CASE SOLUTIONS)	10
		B/O	-19	9	SOCKET CAP SCREW	S.S.	M6 X 1 X 25MM (MCMaster-CARR # 92290A330)	1
		B/O	-21	2	PIN	STEEL	3/16 X 1 (MCMaster-CARR # 98381A510)	1

DART AEROSPACE	
MRH DAMPER SETTING TOOL	
DWG NO. RBEM622V4008101	REV 3
MAT'L	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX $\pm$.005 FRACTIONS $\pm$ 1/8
FINISH	.XX $\pm$.01 ANGLES $\pm$ 5°
SPEC	.X $\pm$.1 SURFACES = 125/
DRAWN BY: MACKOVJAK	1. BREAK ALL SHARP EDGES .015 X 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H175
SCALE 1:5	DATE 3/3/2016 SHEET 1 OF 11

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NOTE:
REF. AIRBUS T/N: M622V4008101.

Part #	UNIT QTY	Description	Material
-1	1	BASE	A36/1018/1020 HR
-3	1	MEASUREMENT BLOCK	303 S.S.
-5	1	SUPPORT 1	303 S.S.
-7	1	SUPPORT 2	303 S.S.
-9	1	SUPPORT 3	6061
-11	1	FASTENER 1	303 S.S.
-13	1	FASTENER 2	303 S.S.
-15	4	CAP	BLACK DELRIN/ACETAL
-17	2	FOAM BLOCK	ETHAFOAM 220, BLACK
-19	9	SOCKET CAP SCREW	S.S.
-21	2	PIN	STEEL

DART
AEROSPACE

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TITLE
MRH DAMPER SETTING TOOL

DWG NO. RBEM622V4008101	REV 3	CUSTOMER 1 OF 1
SCALE 1:8	DATE 3/3/2016	SHEET 11 OF 11